

Work Order ID 144186

April 06, 2016 11:37:09 AM

144186

Page 1

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Assembly (350)
 Start Date: 5/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/6/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SW Date: 20160405 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	D

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

100
 Packaging Memo 0.00
 Packaging

110	Assemble as per dwg	0.00							
-----	---------------------	------	--	--	--	--	--	--	--

110
 HandFinish Memo 0.02
 Hand Finishing

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

120
 QC Memo 0.00
 Quality Control

12 of 20 12/6/2016
 DAS
 38
 9-89
 MAY 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Assembly (350)
 Start Date: 5/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/6/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

/ **DAS**
 27
 9-89
 MAY 27 2016

MC5 MAY 27 2016

MC5 MAY 27 2016

PP 144183

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
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								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Page 1

Work Order ID: 144186

144186

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2530		Manufactured	No			100	Each	2.0000	1	1			
D2530													
Handle Weldment													

Location	Loc Qty	Loc Code
ST379	2	
140965	2	

D2535		Manufactured	No			100	Each	73.0000	2	2			
D2535													
Spring													

Location	Loc Qty	Loc Code
ST008	48	
138588	2	
139657	46	
ST012a	25	
143808	25	

D2537		Manufactured	No			100	Each	23.0000	2	2			
D2537													
Bushing													

Location	Loc Qty	Loc Code
ST008	23	
139004	3	
141054	20	

D3913-041		Manufactured	No			100	Each	0.0000	1	1			
D3913-041													
Long Basket Base Assembly, 350													

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Work Order ID: 144186

144186

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

D3914-041 Manufactured No

100 Each 0.0000 1 1

D3914-041

Long Basket Lid Assembly (350)

134141 2016/06/02

D3917-3 Manufactured No

100 Each 93.0000 6 6

D3917-3

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST058

93

141536

93

6

D3953-3 Manufactured No

100 Each 37.0000 2 2

D3953-3

Gas Spring Stud, Lid

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

37

138388

2

141606

35

2

D3953-7 Manufactured No

100 Each 38.0000 2 2

D3953-7

Spring Spacer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

38

138972

38

2

D3953-9 Manufactured No

100 Each 35.0000 2 2

D3953-9

Gas Spring Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

35

139013

2

141591

33

2

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Work Order ID: 144186

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

D3953-17	Manufactured	No	100	Each	25.0000	2	2	DAS
D3953-17						**	142705	6
Gas Spring Spacer								9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST062	25				
			141477	25				
D3953-19	Manufactured	No		100	Each	32.0000	1	1
D3953-19						**		DAS
Gas Spring Bracket								6
								9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST062	32				
			138913	32				
D3953-21	Manufactured	No		100	Each	24.0000	1	1
D3953-21						**		DAS
Gas Spring Bracket								6
								9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST063	24				
			139553	6				
			141546	18				
D3969-3	Manufactured	No		100	Each	16.0000	1	1
D3969-3						**		DAS
Spring (Basket Lid)								6
								9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST365	16				
			140555	6				
			141701	10				

DAS
6
9-89

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Work Order ID: 144186

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-14A

Purchased

No

100

Each

97.0000

4

4

DAS
6
9-89

AN3-14A

Bolt

Location

Loc Qty

Loc Code

over003

80

m133992

50

m134360

30

ST349

17

m134167

17

AN3-16A

Purchased

No

100

Each

90.0000

2

2

DAS
6
9-89

AN3-16A

Bolt

Location

Loc Qty

Loc Code

GA

45

117441

45

ST348

45

M133790

45

AN5-17A

Purchased

No

100

Each

152.0000

4

4

DAS
6
9-89

AN5-17A

Bolt

Location

Loc Qty

Loc Code

GA

34

117872

34

over003

75

m134606

75

ST337

43

m134055

43

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Work Order ID: 144186

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No 100 Each 89.0000 3 3

AN4-12

Bolt

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST344

89

m133988

49

m134370

40

3

AN310-4 Purchased No 100 Each 108.0000 3 3

AN310-4

Nut

**

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

75

M133990

25

M134180

50

ST331

8

M133790

8

3

AN310C4 Purchased No 100 Each 83.0000 2 2

AN310C4

Nut

**

DAS
6
9-89

Location

Loc Qty

Loc Code

OVER007

30

M134370

30

ST331

53

M133694

3

M133990

50

2

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Work Order ID: 144186

144186

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3	Purchased	No	100	Each	2,061.000	6	6	
MS21042L3							**	34634
Nut								DAG 6 9-89

Location	Loc Qty	Loc Code
FP001	100	
m133790	100	
GA	792	
m133790	6	
m134360	786	
Return2016	1	
M132382	1	
ST304	1168	
m134039	12	
m134360	1156	

MS21042L5	Purchased	No	100	Each	462.0000	4	4	
MS21042L5							**	3
Nut								DAG 6 9-89

Location	Loc Qty	Loc Code
GA	140	
m127813	140	
ST303	322	
m134055	72	
m134567	250	

MS24665-151	Purchased	No	100	Each	171.0000	3	3	
MS24665-151							**	3
Cotter Pin								DAG 6 9-89

Location	Loc Qty	Loc Code
GA	64	
m128401	64	
ST289	107	
m133769	7	
m134294	100	

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Work Order ID: 144186

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

47.0000

2

2

DAS
6
9.89

MS24665-300

COTTER PIN

**

134738

Location

Loc Qty

Loc Code

GA

30

118234

30

ST288

17

M128812

17

DAS
6
9.89

NAS1149F0432P

Purchased

No

100

Each

1,747.000

6

6

NAS1149F0432P

WASHER

**

Location

Loc Qty

Loc Code

ST260a

1000

M134502

1000

ST262

626

M133990

626

st268

121

M132677

121

NAS1149F0563P

Purchased

No

100

Each

114.0000

4

4

NAS1149F0563P

Washer

**

Location

Loc Qty

Loc Code

ST261

114

m133515

114

DAS
6
9.89

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Work Order ID: 144186

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/24/2016

Required Date: 6/6/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

2,281.000

8

8

NAS1149F0332P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

1969

m134134

469

m134257

1500

NAS1149C0432R

Purchased

No

100

Each

1,391.000

2

2

NAS1149C0432R

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

618

m125807

428

m133790

190

ST266

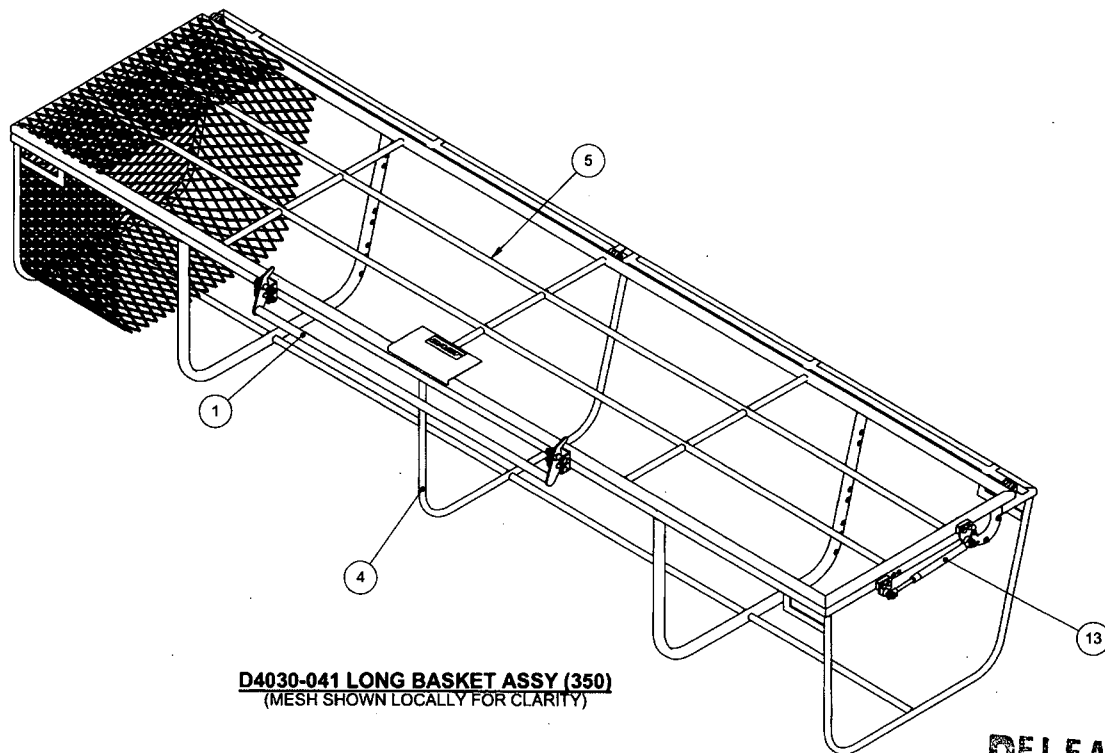
773

m134073

773

MAY 25 2016

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

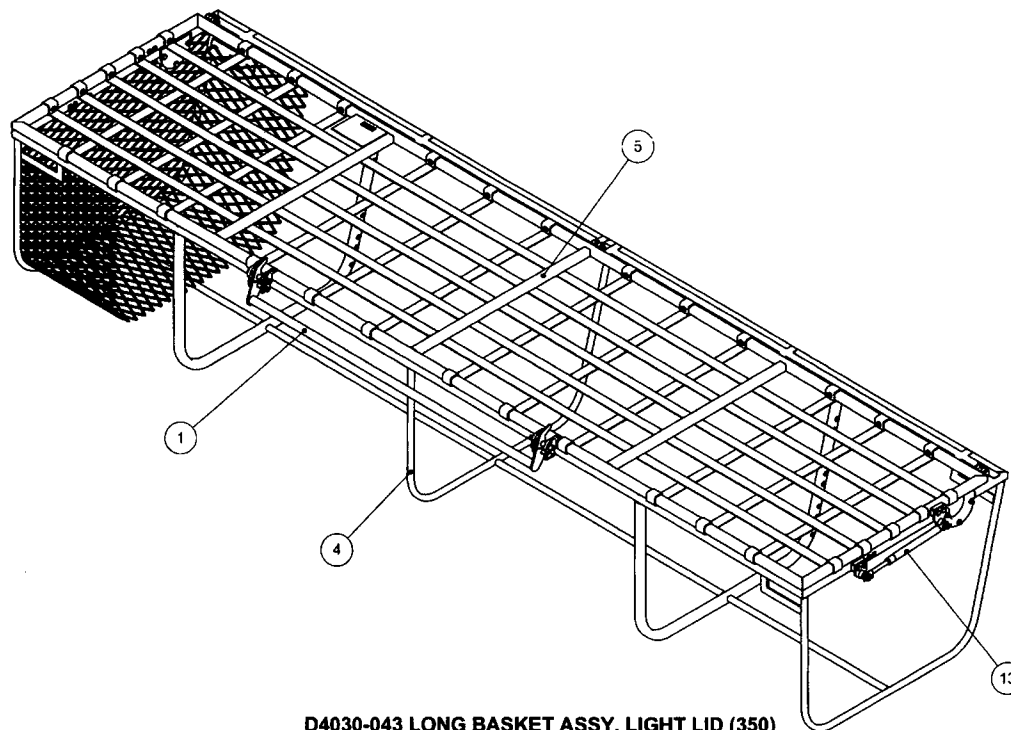
RELEASED
2013-08-16

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 72 lbs APPROX

D	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

20160405
SK 144186

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-08-16
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

